

Date: Tuesday, 2/26/2008 8:02:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WHEEL ASSEMBLY  
 Job Number : 37638 -2  
 Estimate Number : 12099  
 P.O. Number :  
 This Issue : 2/26/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3233041 (2)  
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D3233 REV B  
 Previous Run : 35380 Material :  
 Written By : Due Date : 3/17/2008 Qty: 12 Um: Each  
 Checked & Approved By : 080226  
 Comment : Est. C 05.07.18 D3233-5 was D3332-5; Qty changed by  
 half KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32335 Hub Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Hub Sleeve

Pick:

Qty Part Number Description Batch

1 D3233-5 Hub Sleeve B35399 → 2x 08

2.0 D32337 Shaft Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Shaft Sleeve

Pick:

Qty Part Number Description Batch

1 D3233-7 Shaft Sleeve B35400 → 2x 08

3.0 D32339 Tire &amp; Rim Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Tire &amp; Rim Assembly

Pick:

Qty Part Number Description

1 D3233-9 Tire &amp; Rim Assembly

Batch

B35436 → 2x 08  
~~B35380~~ → 2x

4.0 NKI 3020 BEARING



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bearing

Pick:

Qty Part Number Description

2 NKI 30/20 Bearing & Inner Sleeve M107280 → 4x 08/03/06

Batch

Date: Friday, 2/20/2009 10:42:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 37638

Part Number: D3233041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SHIM STOCK

.004" Brass Shim Stock



Comment: Qty.: 4.0000 f(s)/Unit Total: 48.0000 f(s)

.004" Brass Shim Stock

Pick:

Qty Part Number Description

Batch

4 Shim Stock 0.004" thick Brass Shim Stock

M107282

JS

6.0

35X45X7

Bearing Seal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bearing Seal

Pick:

Qty Part Number Description

Batch

2 35x45x7 Axel Seal

M107280 → 4x

or CR 35x45x7 HMS4 R

JS

08/03/06

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Press out bearings that are supplied with D3233-9 wheel and discard them. ✓

Cut shims and assemble as per Dwg D3233 ✓

Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage. ✓

JS 08/03/06 (2x)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/03/06 (2x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: (STEVE)

JS 08/03/06 (2x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/03/07

Job Completion

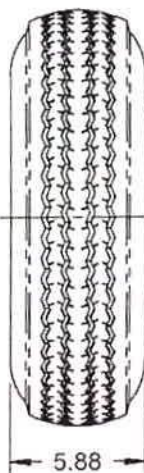
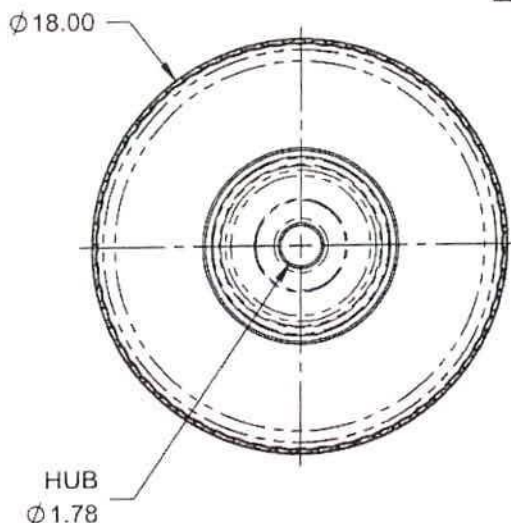


JS 08/03/07



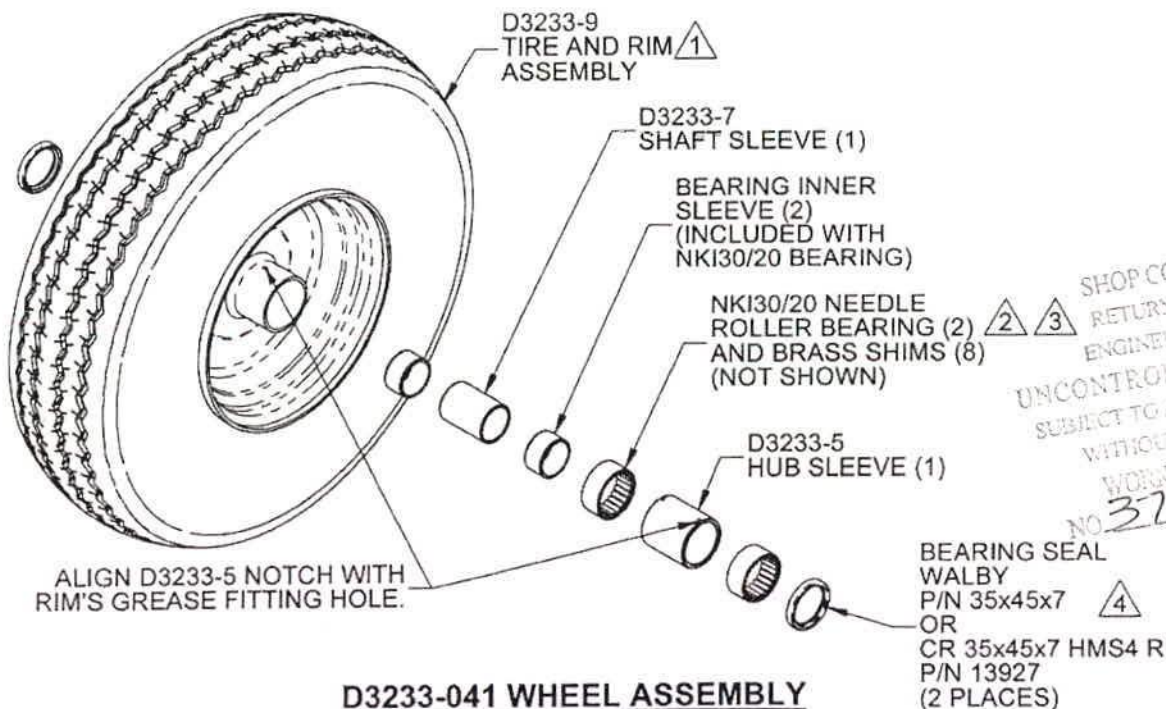
**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**  
*[Signature]*  
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

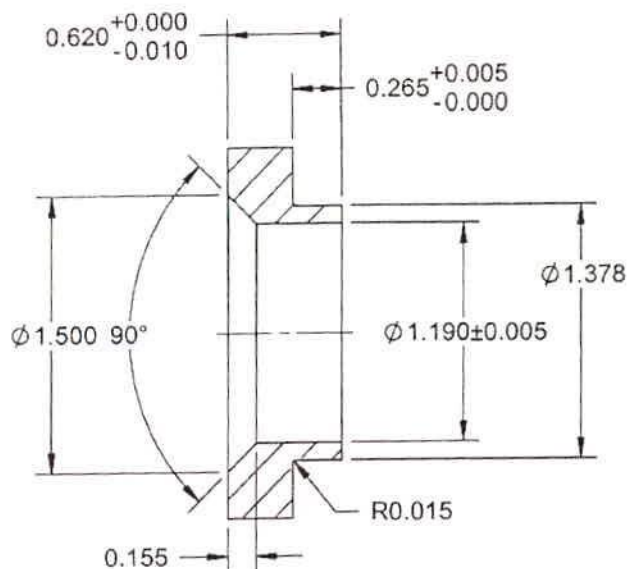
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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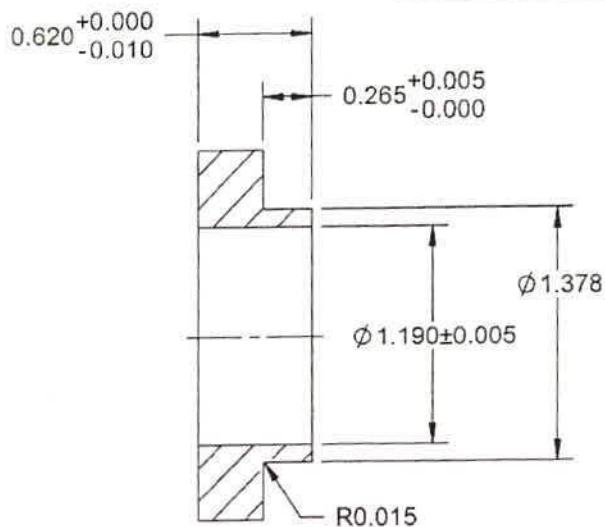
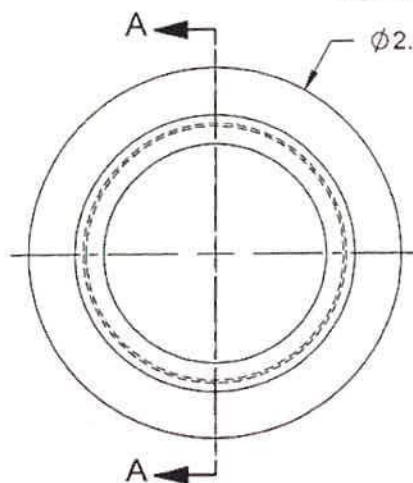


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



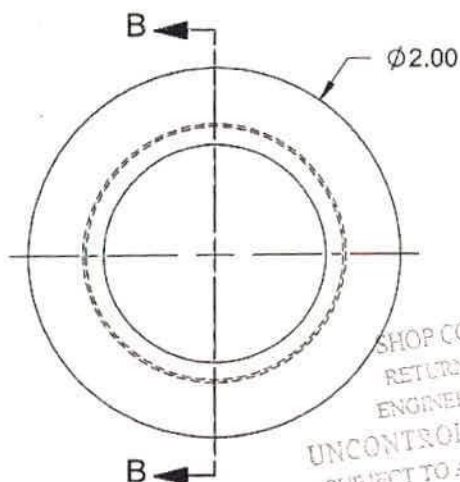
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37638

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

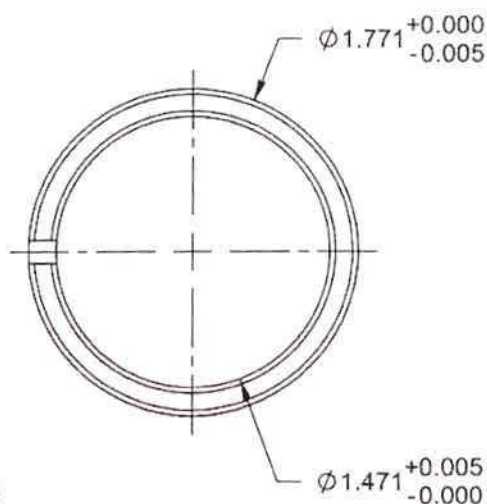
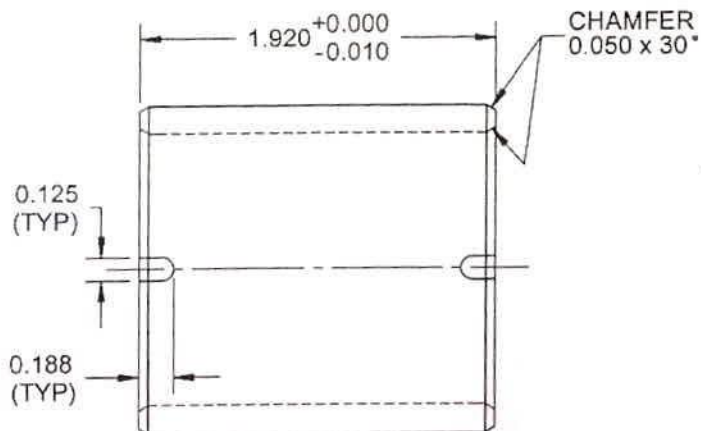
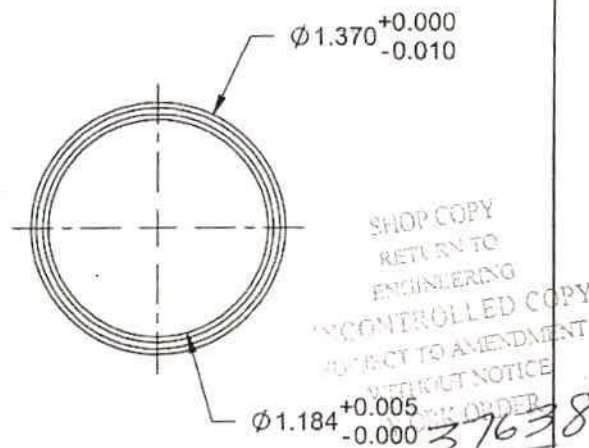
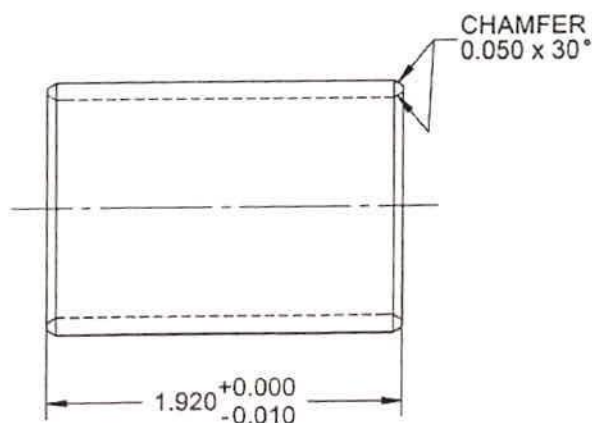
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1	

**RELEASED**  
*[Signature]*  
05/05/04**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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